

Work Order ID 61870

Wednesday, September 08, 2010 1:34:03 PM



Page 1

Item ID: D4078-1

Accept



Setup Start



Revision ID:

Item Name: Clamp Half

Stop



Start Date: 9/8/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-9-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4078

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.700" long

8/10/09/25

12 8

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev: *A*

Dwg Rev: *B*

HA 10/09/26

12 0

Deburr

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Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

M.A 10/09/26

12

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

CMR 10/09/26

12

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BR 10-9-27

12

0

Hand Finishing

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Setup Start



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Stop



Item Name: Clamp Half

Start Date: 9/8/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

BL 10-9-09



Powdercoat

M112588

Memo

START. 10:35

0.00

QTY 7.320

Finish 11:05

12

0

Powder Coating

160

QC3- Inspect Part Finish

0.00

=> M 10/09/29



QC

Memo

0.00

12

0

Quality Control

170

Identify as per dwg & Stock Location: 23

0.00



Packaging

Memo

0.00

10/9/09 SP

12x

Packaging

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Item ID: D4078-1

Accept

Revision ID:

Item Name: Clamp Half

Start Date: 9/8/2010 Start Qty: 12.00

Required Date: 9/13/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30 *[Signature]**mk*
10-9-29

Picklist Print

Wednesday, September 08, 2010 1:34:07 PM

Page 1

Work Order ID: 61870

Parent Item: D4078-1

Parent Item Name: Clamp Half



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	13.6290	0.223	2.816842			



6061-T6 Bar 1.25 x 1.25



28 10/09/25

Location

MAT03

106259

110001

Loc Qty

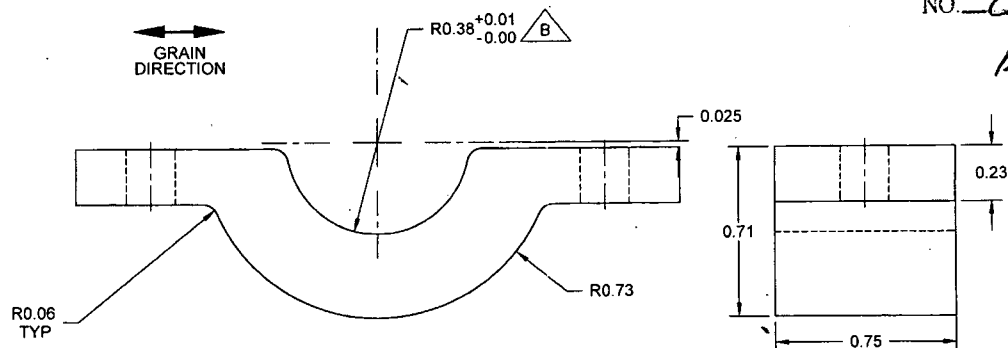
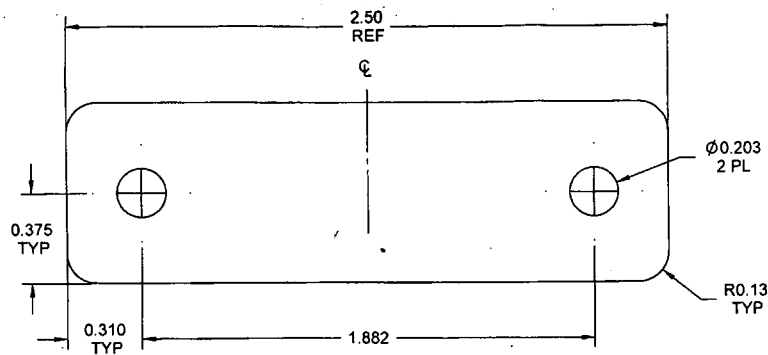
13.62895053

7.06921053

6.55974

Loc Code

2.8169



D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

SHOP ONLY
REVISION
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A REVISION
WITH THE WORK
WORK ORDER
NO. *CL8-70*
B810-9-08

RELEASED
2010-09-07
MP

B	R0.38 was R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	10/07/30		
DE APPR.	JB		
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4078	REV. B SHEET 1 OF 1
TITLE CLAMP HALF	SCALE NTS
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